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D3488-4

Job Sheet 191065



Part No: D3488-4

Job Qty: 6 pcs

Part Name: Blade Fitting, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/21/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DSK101 REV.D / D3488 REV.C IPP REV:A 18.11.09 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Doosan - 1	6 pcs	3/18/19	3/18/19	0.00	5.27	Doosan - 1			DAS 5 8-89
110	QC 2	6 pcs	3/18/19	3/18/19	0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			
							QC 2 - 54			
							QC 2 - 56			
							QC 2 - 57			
							QC 2 - 62			
							QC 2 - 63			
							QC 2 - 8			



Container No: S179461



Part: D3488-4

Job No: 191065

Serial No/Batch: S179461

Revision: D/C

Inspector:

Exp Date:

Instructions:

Date: 05/08/19

120 HAAS 4 Axis - B4B	6 pcs	3/18/19	0.11 4.11	QC 2 - 66	
				QC 2 - 64	
				HAAS - 1 - B4B	
				HAAS - 2 - B4B	
				HAAS - 3 - B4B	DAS
130 QC 2	6 pcs	3/18/19	0.00 0.00	HAAS - 4 - B4B	64
				QC 2 - 1	9-89
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
140 QC 8	6 pcs	3/18/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
150 Handfinish - 1-1 Chemical-	6	3/18/19	0.00 0.18	Handfinish - 1 - 1 - B4B	

B4B	pcs				Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	D.R.19/05/14
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White Gl(A)- B4B	6 pcs	3/18/19	0.00 0.21	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
170	QC 3	6 pcs	3/18/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 26	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	
					QC 3 - 68	
					QC 3 - 9	
200	Packaging 3-1 - Stock - B4B	6 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	

Plex 2/21/19 8:41 AM Dart.lajeunesse.marie

DAS
15
9-89

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-001 11 14-5-15
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210 QC 21 - SA	6 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-02
Part Op 100 - Doosan (Doosan Lathe) 1-Turn as per Dwg DSK 101 & Folio FC492 Descriptions: 110 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB) 120 - HAAS1-3 (HAAS CNC Vertical Machine) 1-Machine as per Folio FA627 & Dwg D3488 130 - QC2 Machining-2 (QC2- Inspect parts off machine FAI/FAIB) 140 - QC8 Machining-2 (QC8- Inspect parts - second check) 150 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1) 160 - Powdercoat1 (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ 170 - QC3 (QC3- Inspect Part Finish) 200 - Packaging3-1 (Identify as per dwg & Stock Location: _____ LOCATION : FP001 210 - QC21 (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D6103-003	Round Billet, Aluminum	6 pcs (1 ea)	100-Doosan - 1	S150863 X3 S141243 X3	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Doosan - 1	D6103-003	6	27	0	
Part Specifications					
Specifications could not be found.					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	191065
Description: Blade Fitting, RH / Turning Detail for D3488- 02 4		Part Number:	D3488- 2 4
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 1 of 2	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments	
Lathe Section							
Ø2.150	+/-0.005	2.150			Caliper		
Ø2.780	+/-0.005	2.781					
Ø3.125	+/-0.010	3.124					
Ø3.346	+/-0.010	3.347					
0.125 x 45°	+/-0.010 x +/-0.1°	.13 x 45°					
8.000	+0.030/-0.000	8.016					
9.250	+/-0.010	9.2495					
0.188	+/-0.010	.1885					
R0.032	+/-0.010	R.032					
R0.062	+/-0.010	R.062					
Ø0.297	+0.005/-0.001	X					
Ø0.430	+/-0.010						
0.100	+/-0.010						
0.200	+/-0.010	.197					
2.620	+/-0.010	2.6195					
3.500	+/-0.010	X					
1.005	+/-0.010						
Ø0.484	+0.005/-0.001	.486					
1.180	+/-0.010	1.178					
3.150	+/-0.010	3.149					
3.070	+/-0.010	3.065					
R0.063	+/-0.010	R.062					

DART AEROSPACE LTD		Work Order:	
Description: Blade Fitting, RH / Turning Detail for D3488 <i>4/2</i>		Part Number:	D3488 <i>2C/</i>
Inspection Dwg: D3488 / DSK101 Rev: C / D		Page 2 of 2	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Milling Section						
Ø0.508	+0.006/-0.001	.508 <i>8</i>	✓		Pin gauge	
0.750	+/-0.010	.750	✓		high gauge	
1.500	+/-0.010	1.498	✓		Vernier	
11.18	+/-0.030	11.178	✓		high gauge	
R0.062	+/-0.010	R.062	✓		Gaborit	
0.125	+/-0.010	.129	✓		Vernier	
0.590	+/-0.010	.583	✓		high gauge	
0.793	+/-0.010	.797	✓		Vernier	
1.351	+/-0.010	1.354	✓		high gauge	
1.317	+/-0.010	1.310/1.316	✓		Vernier	
1.802	+/-0.010	1.800	✓		high gauge	

Measured by: <i>De Juv</i>	Audited by: <i>smgml</i>	Prototype Approval:	N/A
Date: 19/05/13	Date: 19/05/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.03.31	New Issue	KJ/JLM	
B	08.09.19	Reformat P/O D3488-042	KJ/JLM	
C	08.12.02	Dimension 8.000 removed	KJ/JLM	
D	18.11.22	Dimension 0.125 changed to 0.200	MS <i>mf.</i>	<i>M</i>